



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4824-1

Job Sheet 186584



Part No: D4824-1

Job Qty: 8 ea

Part Name: Upper Cutter Mount



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/17/18

Job Tracking No:

Due Date: 1/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D4824 rev.a IPP REV:A NEW ISSUE 13-04-26 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		1/4/19	0.00	0.00	Start Up Machining-3		SBL 19/02/03
100	Bandsaw	8 pcs		1/4/19	0.00	0.01	Bandsaw1		SBL 19/02/03
110	CNC Vertical Machining	8 pcs		1/4/19	0.26	20.51	HAAS1-5		SBL 19/02/03
120	QC	8 pcs		1/4/19	0.00	0.00	QC2 Machining-3		SBL 19/02/07
130	QC	8 pcs		1/4/19	0.00	0.00	QC8 Machining-3		mark 19/02/11
140	Outsource	8 pcs		1/4/19			ATG001-VC	5	6219-02-12
150	Packaging	8 pcs		1/4/19	0.00	0.00	Packaging2		MAR 11 2019 DAS
155	QC	8 pcs		1/4/19	0.00	0.00	QC5		MAR 11 2019 68
170	QC	8 pcs		1/4/19	0.00	0.00	QC14		MAR 11 2019 68
180	Packaging	8 pcs		1/4/19	0.00	0.00	Packaging3-2	045036	MAR 12 2019 68
190	QC21-SA	8 Ea		1/4/19	0.00	0.00	QC21		MAR 13 2019 70

Part Op 100 - CUT BLANK AT 12.100"

Descriptions: 110 - 1-Machine per folio FB188 DWG REV: _____ FOLIO REV: _____ 2- deburr and break all sharp edges

140 - Issue P/O: 042555 Black Anodize as per Dwg D4824 PRIME AS PER DWG, SEE NOTE #2

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6B1.750X4.500	7075-T6 Bar 1.750" X 4.500"	8.0640 ft (1.008 ea)	90-Start up Operation	7138251-1777
				5072142

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6B1.750X4.500	8	0	0

Part Specifications

Specifications could not be found.

Plex 11/19/18 11:36 AM Dart.lajeunesse.marie

Raw Mat.
S150365

needs to add job
Bom to add 1 more billet
@ Qc 8 to ping Qty.
- Back to 8.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																		
Date :	Step #:	QTY Effective :	MRB (QSI042) Approval																																																	
Description Work Order Deviation		Disposition																																																		
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 02/03/19		Completed By 																																																		
		Lead hand / Supervisor Approval Verification 																																																		
		QC / QA Coordinator Approval 																																																		
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DART AEROSPACE LTD		Work Order:	186589
Description: Upper Cutter Mount		Part Number:	D4824-1
Inspection Dwg: D4824 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.731	+/-0.010	.731	✓			
1.05	+/-0.030	1.043	✓			
0.24	+/-0.030	.234	✓			
1.6	+/-0.100	1.566	✓			
5.4	+/-0.100	5.432	✓			
R0.13	+/-0.030	.125	✓			
1.3	+/-0.100	1.253	✓			
0.47	+/-0.030	.473	✓			
R0.25	+/-0.030	.250	✓			
Ø0.177	+0.005/-0.001	.177	✓		R.C.	
6.250	+/-0.010	6.248	✓			
4.367	+/-0.010	4.366	✓			
2.083	+/-0.010	2.083	✓			
1.635	+/-0.010	1.635	✓			
R0.19	+/-0.030	.190	✓			
0.340	+0.000/-0.003	.339	✓			
R0.13	+/-0.030	.125	✓			
R0.5	+/-0.100	.500	✓			
3.2	+/-0.100	3.230	✓			
2.126	+/-0.010	2.128	✓			
11.8	+/-0.100	11.768	✓			
R1.6	+/-0.100	1.600	✓			
2.925	+/-0.010	2.926	✓			
4.0	+/-0.100	4.027	✓			
Ø0.197	+0.005/-0.001	.197	✓			
R0.6	+/-0.100	.625	✓			
6.692	+/-0.010	6.693	✓			
0.94	+/-0.030	.938	✓			

Measured by: DAS 57		Audited by: myml		Preliminary Approval:	
Date: 9-89 19/02/04		Date: 19/02/11		Date:	
Rev	Date	Change	Revised by	Approved	
A	15.10.14	New Issue	KJ	 	



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200
Fax 613 632-5246

Inventory

Operation Number	Operation	Container No	Job	Master Unit Number	Quantity	Weight	Serial No/Batch	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No	Expiration Date	Inventory Type
Part Number: M7075T6S1.750X4.500 Revision: M7075T6 Sheet 1.750 Thick X 4.500 Wide																	
100	Receive Ft	S072142			12 ft	0		MAT		Stock	5/17/2018	*					
Operation Totals:		1			12	0											
Part Totals:		1			12	0											
Totals:		1			12	0											

Plex 12/7/2018 8:05 AM Dart.Lavoie.Chantal

DQA: _____ Date: 19/02/04**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>186.584</u> Part No. <u>D4824-1</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Operator put the drill wrong drill in the machine. hole is bigger (over) than the tolerance				scrap/destroyed replaced Qty/ Batch																																																																			
				Completed By DAS 57 9-89 <u>19/02/04</u>																																																																			
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042585



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042585

PO Date: 2/12/19

Due Date: 3/6/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	188352	646.3012	Lower Guide Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3000	Firmed	-	3/6/19	20 pcs	0 pcs	20 pcs	\$21.73/pcs	\$434.60
3	188351	646.3011	RH Half (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Black Anodize, Color Black and Prime as Per Dwg 646.3000	Firmed	-	3/6/19	20 pcs	0 pcs	20 pcs	\$12.08/pcs	\$241.60
4	187493	646.3010	LH Half Outsource4 (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 646.3000	Firmed	-	3/6/19	10 pcs	0 pcs	10 pcs	\$12.08/pcs	\$120.80
5	190359	647.3917	Doubler Issue P/O to ATG : HARD ANODIZE, COLOR BLACK, AND PRIME AS PER DWG 647.3900 REV. C	Firmed	-	3/6/19	12 pcs	0 pcs	12 pcs	\$8.43/pcs	\$101.16



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PURCHASE ORDER PO042585



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	186584	D4824-1	Upper Cutter Mount : Various STC's Issue P/O: Black Anodize as per Dwg D4824 PRIME AS PER DWG, SEE NOTE #2	Firmed	-	3/6/19	8 pcs	0 pcs	8 pcs	\$15.23/pcs	\$121.84

8X MAR 11 2019

Line Item Note: * as soon as possible *

Grand Total: \$1,020.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/5/19 8:15 AM dart.tsimiklis.chrisoula

OR



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917402

Date: 08-Mar-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 8 ea	Part: D4824-1 Upper Cutter Mount Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - 2 mils) per drawing. Job: 24629	Rev: A	PO: PO042585 ✓ Line: 7
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAR 08 2019</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			